DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 1.28

WELDING INSPECTION REPORT

Resident Engineer: Casey, William
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-028114
Date Inspected: 01-Aug-2012

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: American Bridge/Fluor Enterprises, a JV

OSM Arrival Time: 700
OSM Departure Time: 1930
Location: Job Site

CWI Name: See Below

Inspected CWI report:	☐ Yes	☑ No	☐ N/A	**CWI Present:**	☑ Yes	☐ No	
Electrode to specification:	☑ Yes	☐ No	☐ N/A	**Rod Oven in Use:**	☑ Yes	☐ No	☐ N/A
Qualified Welders:	☑ Yes	☐ No	☐ N/A	**Weld Procedures Followed:**	☑ Yes	☐ No	☐ N/A
Approved Drawings:	☑ Yes	☐ No	☐ N/A	**Verified Joint Fit-up:**	☑ Yes	☐ No	☐ N/A
				Approved WPS:	☑ Yes	☐ No	☐ N/A
				Delayed / Cancelled:	☐ Yes	☑ No	☐ N/A

Bridge No: 34-0006
Component: OBG/Tower

Summary of Items Observed:

At the start of the shift this Quality Assurance Lead Inspector (QAI) traveled to the SAS project site and observed the work and the inspection performed by American Bridge/Fluor Enterprises (AB/F) Quality Control (QC) personnel. The observations and inspections were performed as noted below:

A). This Quality Assurance Lead Inspector (QALI) assigned the QA Inspectors to the following, but not limited to the work station(s) listed, to observe the welding and the QC inspection of the following:

Rodney Patterson-OBG W14 (Observation of welding, QC inspection and testing of the longitudinal diaphragm stiffener), OBG Field Splice W13/W14 (Observation of welding, QC inspection and testing of deck stiffener flange at the longitudinal stiffener identified as LS1) and OBG W13 Drop-In (Observation of excavation, repair welding, QC inspection and testing).

Fritz Belford-OBG W12 Drop-In Assembly (Observation of welding, QC inspection and testing) and QA VT/MPT/UT verification.

Doug Frey-OBG Field Splice E12/E13 (Observation of welding, QC inspection and testing of edge plate and deck stiffener flanges), E12 Corner Drop-In Ass'y(Observation of welding, QC inspection and testing of longitudinal and transverse field splices) and Lifting Lug Removal (Observation of welding, QC inspection and testing of the Rib Stiffener "B").

Matt Daggett-Tower Saddle Housing/Grip Plates(Observation of assembly fit-up, welding, QC inspection and

testing)

William Clifford-Tower Shear Plates/ESW "P" & "Q"(Observation of excavations, repair welding, QC inspection and testing) and QA/MPT verification of excavations.

NOTE: See QA daily Weld Inspection Reports (WIR) and NDE reports for additional information and details.

Quality Assurance Lead Inspector (QALI) Summary

This QA Lead Inspector (QALI) observed the QA Inspector's Joselito Lizardo, William Clifford, Rodney Patterson and Fritz Belford and Matt Daggett monitor the work performed by the QC inspectors at random intervals and also observed the QA Inspectors verify the welding parameters, the minimum preheat and the maximum interpass temperatures for compliance with the contract specifications. The QAI's utilized a Fluke 337 clamp meter to measure the electrical welding parameters, Tempil Heat Indicators and/or a Fluke 63 IR Thermometer for verifying the preheat and interpass temperatures. At the conclusion of the shift, this QA Lead Inspector discussed and reviewed the work performed by the QAI's in regards to the various observations and the verifications of the WPS's, consumables, welding parameters, preheat and interpass temperatures. The QAI observations of the QC inspection and verification of the welding parameters performed on this date appeared to comply with the contract specifications and no issues were noted during this shift.

This QA Lead Inspector commence the review of NDT reports, tracking of welding and developing and generating weld maps for W13 drop-in panels, E12 and W12 corner drop-in assemblies. This QA Lead Inspector also reviewed RWR documents for tracking purposes.

Summary of Conversations:
At the start of the shift, there were general conversations with Quality Control Lead Inspector, Bonifacio Daquinag, Jr., at the start of the shift regarding the location of welding, inspection personnel scheduled for this shift.

There were also, other pertinent conversations with QA Supervisor, William Levell, throughout the course of this shift in regards to scheduling of QA personnel, work progress and related structural steel and weld issues. There were no significant issues noted on this date. This QALI met with QA Supervisor, William Levell and Structural Material Representative (SMR) Bahjat Dagher and Bob Kick, ABF Operations Manager, Eric Blue, ABF Engineer, James Bowers, ABF Welding Quality Control Manager (WQCM) and QC Lead Inspector Bonifacio Daquinag, Jr. to review and discuss the spreadsheet document generated by ABF and the pertinent information entered.

Also, this QALI was informed by QA inspector, Fritz Belford, regarding the excessive root openings located at OBG W12 drop-in assembly weld joints identified as 12W-PP116.5-BW2 and 12W-PP115.5-BW2. At the conclusion of QA discussion regarding the issue it was determined that root openings did not exceed 20 mm allowed by the contract documents and would not require engineers approval.

Comments
This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy 510-385-5910, who represents the Office of Structural Materials for

your project.

Inspected By:	Reyes,Danny	Quality Assurance Inspector
Reviewed By:	Levell,Bill	QA Reviewer